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SOURCE Tekhnika-Molodezhi, No 10USSR MODEL MK-159 VERTICAL LATHE

A. Rybkin, deputy chief
 Technical Admin of
 Ministry of Machine
 Building USSR

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The table speed of the Model MK-159 vertical lathe produced by the Kolonna Heavy-Machine-Tool-Building Plant depends on the weight of the workpiece. If the workpiece weighs up to 0.5 tons, it can be machined at a speed of 5 table rpm or faster. If the workpiece weighs from 150 to 170 tons, it can be machined at a speed of not greater than 2 table rpm. However, the cutting speed in machining large-diameter blanks can reach 200-300 meters per minute. The total cutting force [in machining] a 7-meter diameter reaches 20 tons.

In roughing operations, it is possible to use a feed of 5-12 millimeters per table revolution and a depth of cut of 40-60 millimeters. In finishing operations, with a wide cutting tool, a feed of up to 120 millimeters can be used.

At present, Soviet engineers are working on another large vertical lathe on which parts more than 20 meters in diameter can be machined. This machine tool is scheduled for manufacture in 1954.

[Other information on Model MK-159 has been reported in
 and in page 3, top.]

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